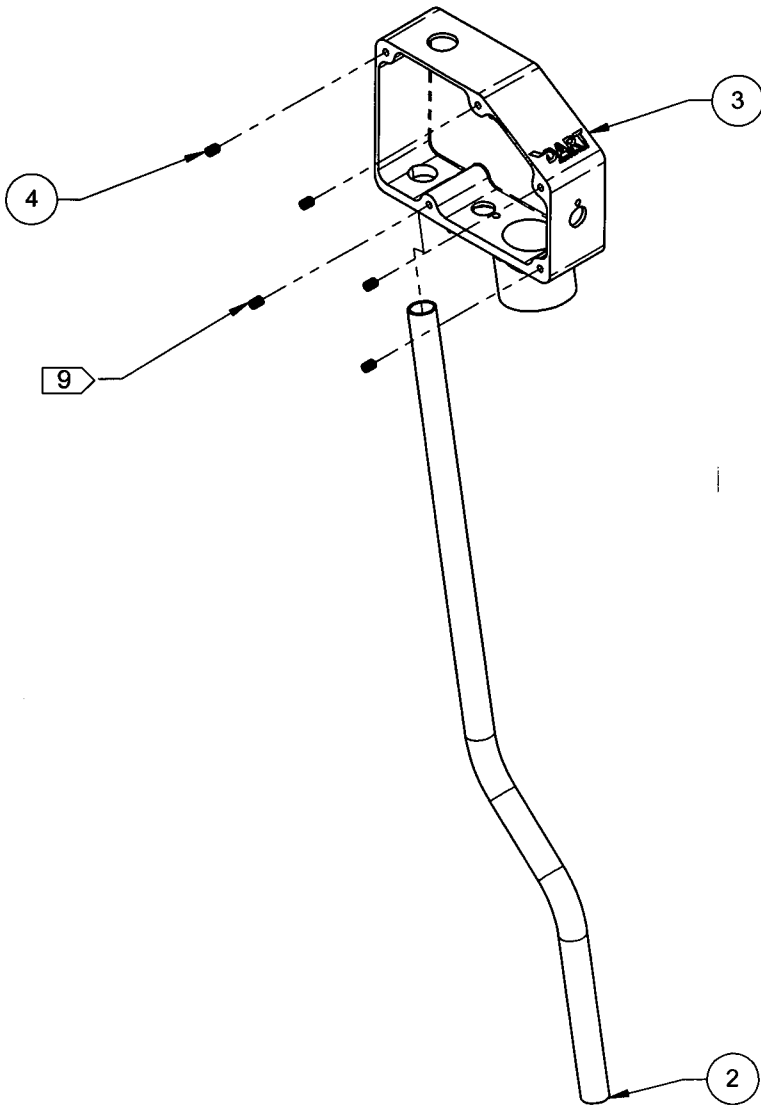


ITEM	QTY -041	P/N	DESCRIPTION
1	X	D5046-041	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)
2	1	D4410-7	CONDUIT
3	1	D5046-1	CO-PILOT COLLECTIVE HEAD
4	5	90296A108	HELI-COIL INSERT (6-32 X 0.276)



**D5046-041 CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)**

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
  - 7) WEIGHT: 0.97 lbs
  - 8) WELD PER DART QSI 004
  - 9) INSTALL AFTER ANODIZING

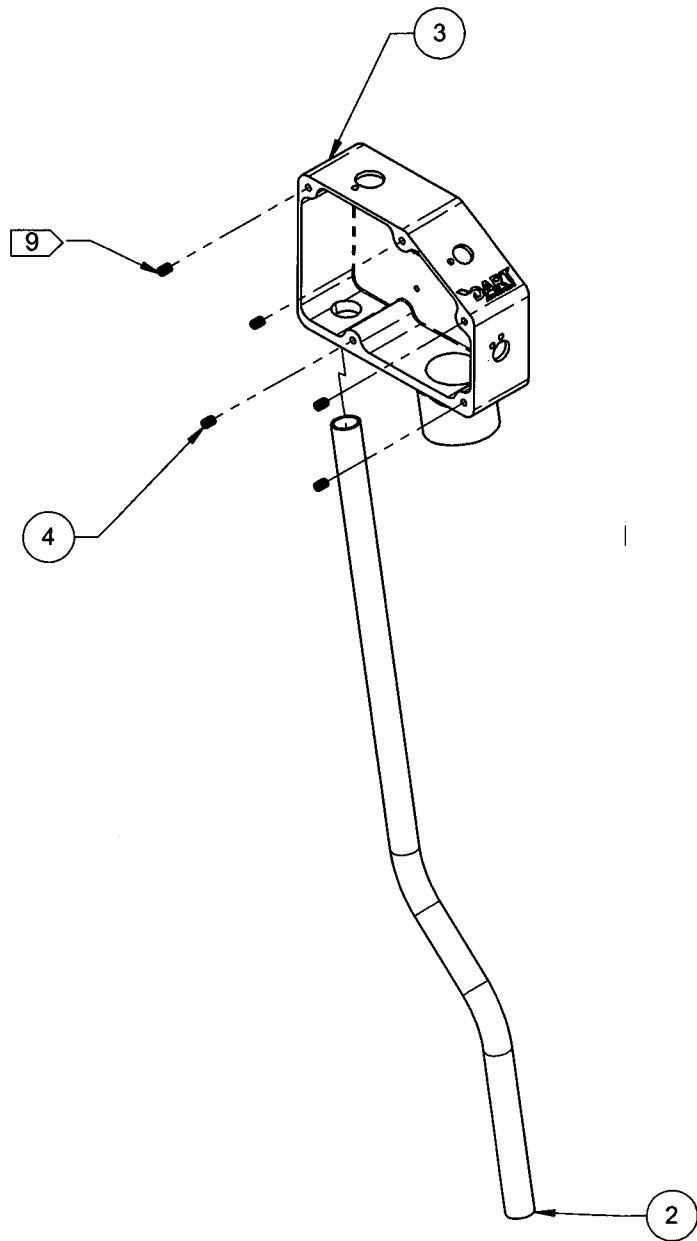
**RELEASED**  
A.P. 2015 JUL 02 ECN 15-577

**D5046-041 WELDING DETAIL**

B	REVISE C'BORE DIM, ZN B3-5, B6-9, B6-11, REVISE HOLE DIM, ZN B2-6, B1-10, B4-12, REVISE HOLE LOCATION ZN C5-8, B4-8, REVISE NECK LENGTH AND REMOVE MOUNTING HOLE, ZN C4-5, B4-7, C4-9, REMOVE PIN FROM BOM, ZND6-1, D6-2, D5-3, REVISE DIM, ZN C5-8, D5-5, B4-7, D5-9, D5-11, D8-6, D8-8, D8-10, C6-6, C6-8, D5-10, D6-12	VS	14.11.20
A	NEW ISSUE	VS	14.01.22
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5046	SHEET 1 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	14.11.20	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D5046-043	CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)
2	1	D4410-7	CONDUIT
3	1	D5046-3	CO-PILOT COLLECTIVE HEAD
4	5	90296A108	HELI-COIL INSERT (6-32 X 0.276)

B



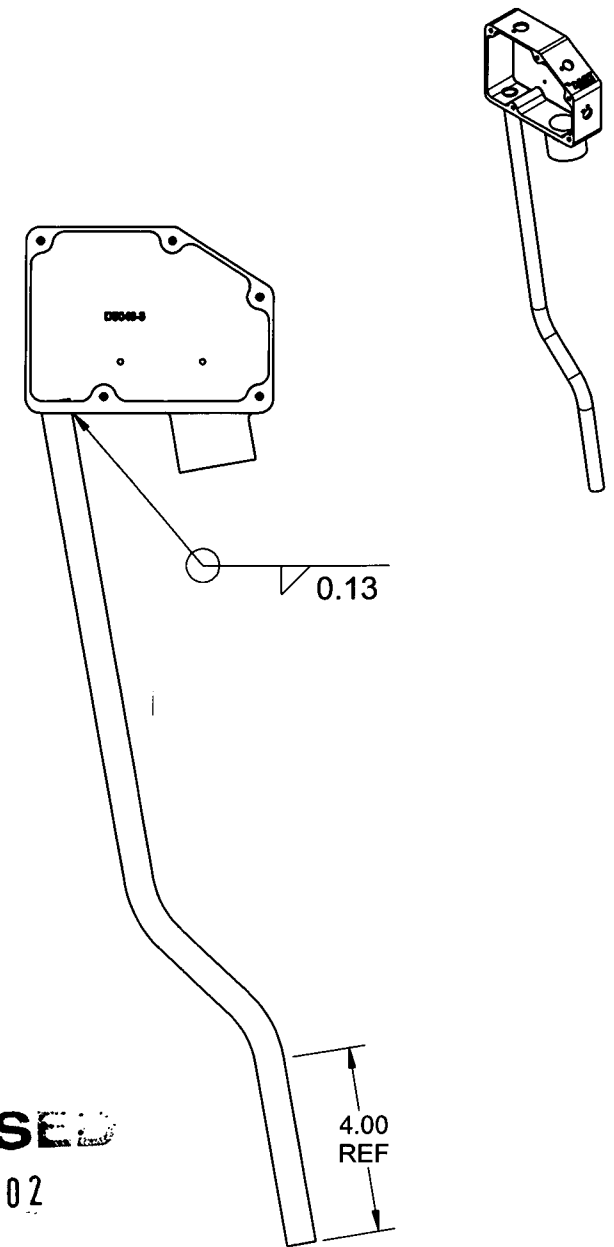
D5046-043 CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING

RELEASED

A.Q. 2015 JUL 02

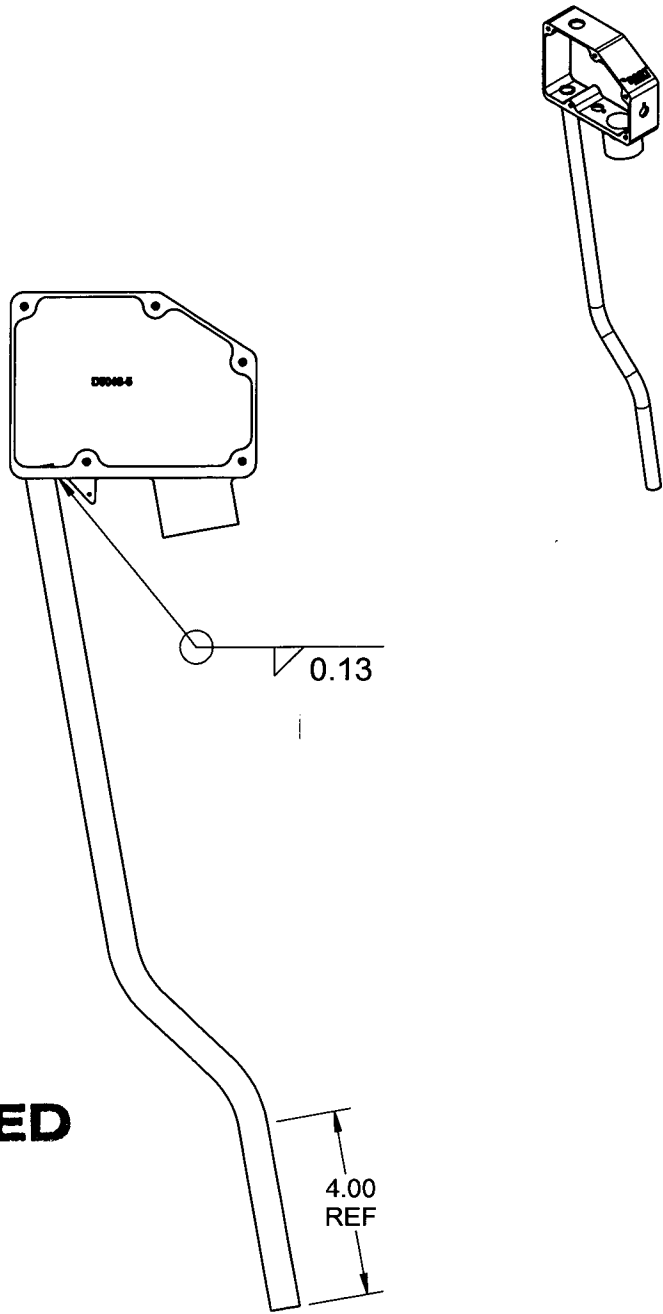
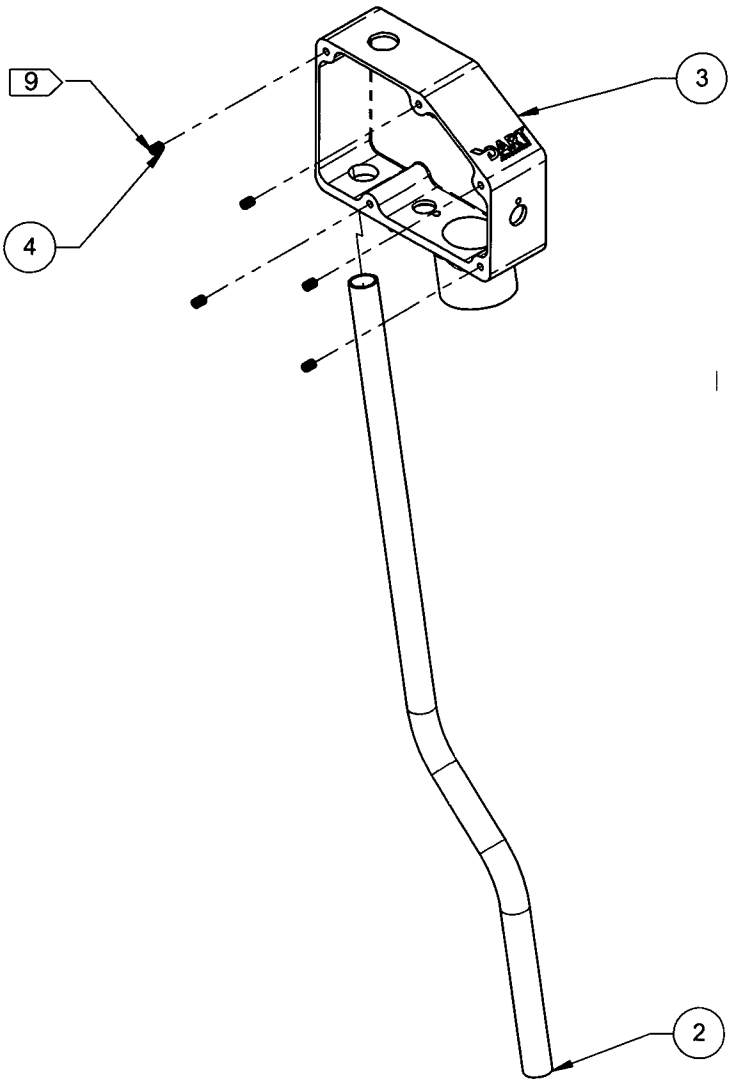


D5046-043 WELDING DETAIL

APPROVED

DESIGN	VS	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5046	SHEET 2 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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ITEM	QTY	P/N	DESCRIPTION
1	X	D5046-045	CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE)
2	1	D4410-7	CONDUIT
3	1	D5046-5	CO-PILOT COLLECTIVE HEAD
4	5	90296A108	HELI-COIL INSERT (6-32 X 0.276)



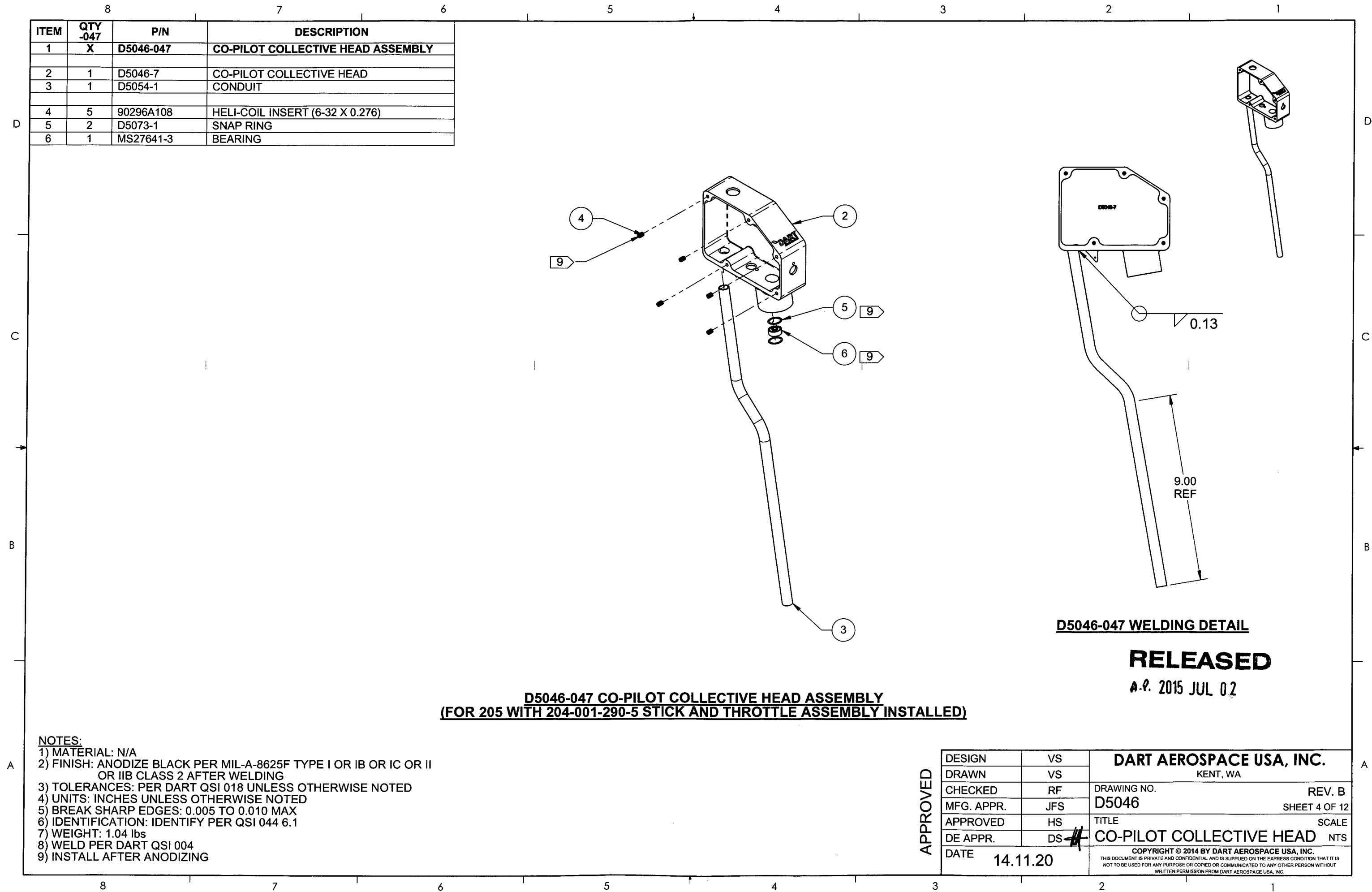
RELEASED  
4-P. 2015 JUL 02

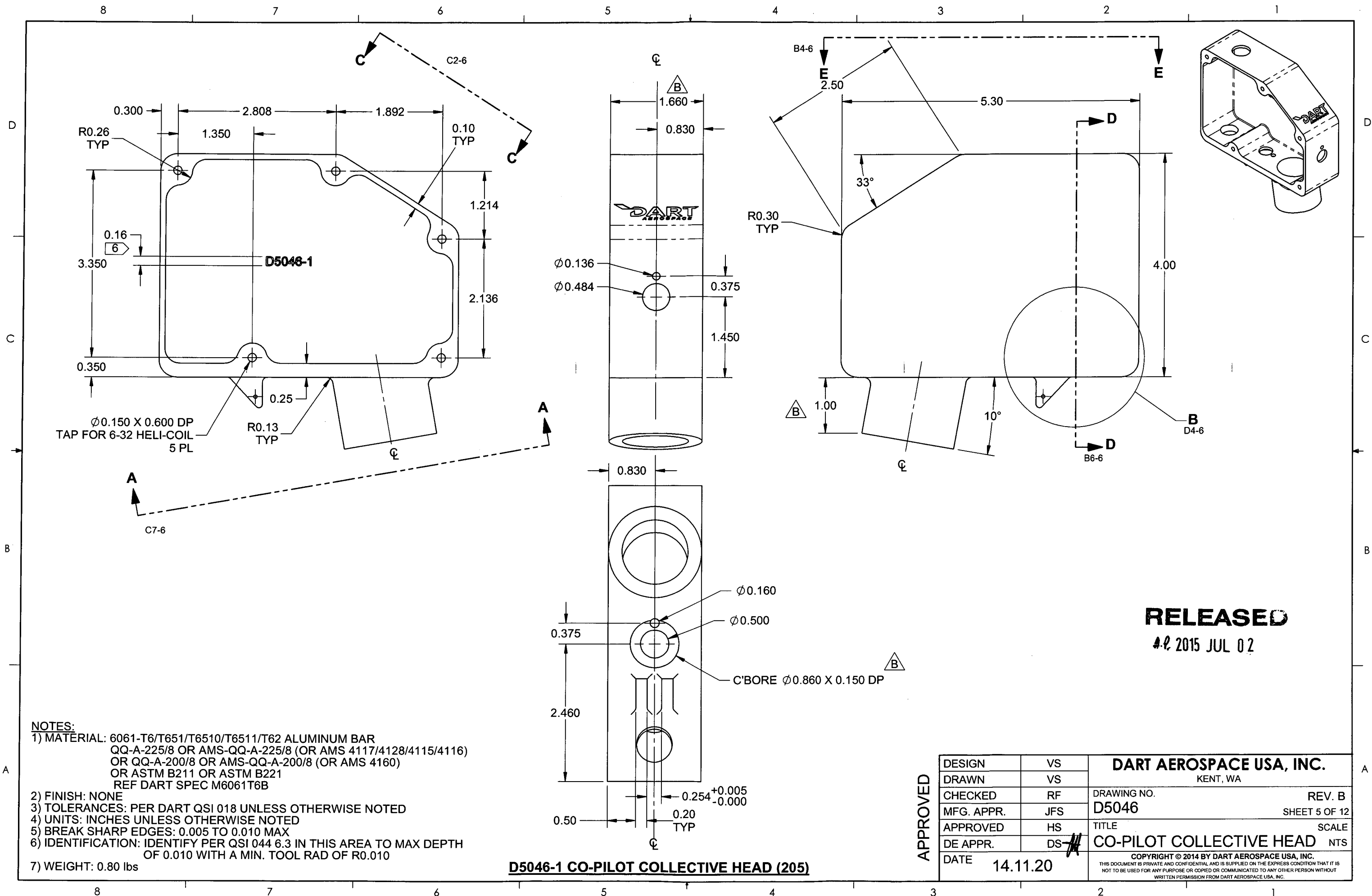
D5046-045 CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE)

D5046-045 WELDING DETAIL

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
  - 7) WEIGHT: 0.96 lbs
  - 8) WELD PER DART QSI 004
  - 9) INSTALL AFTER ANODIZING

DESIGN	VS	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5046	SHEET 3 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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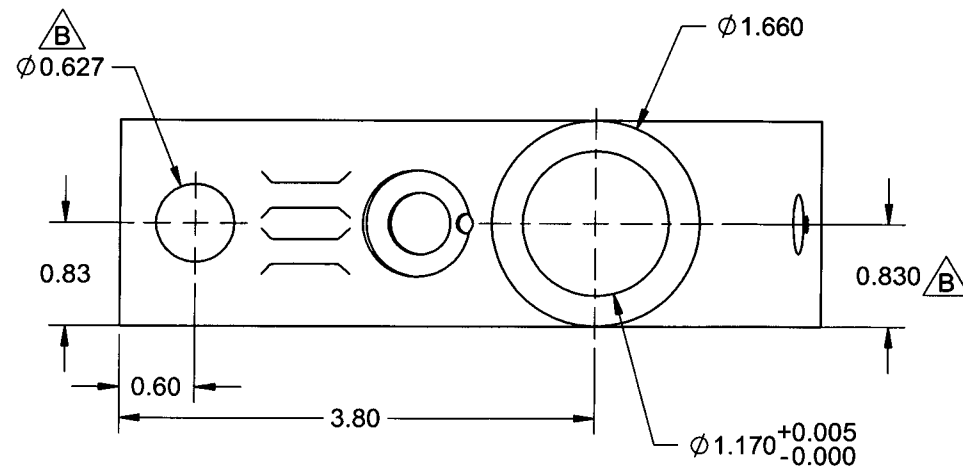


NOTES:  
 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
 QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
 OR ASTM B211 OR ASTM B221  
 REF DART SPEC M6061T6B  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH  
 OF 0.010 WITH A MIN. TOOL RAD OF R0.010  
 7) WEIGHT: 0.80 lbs

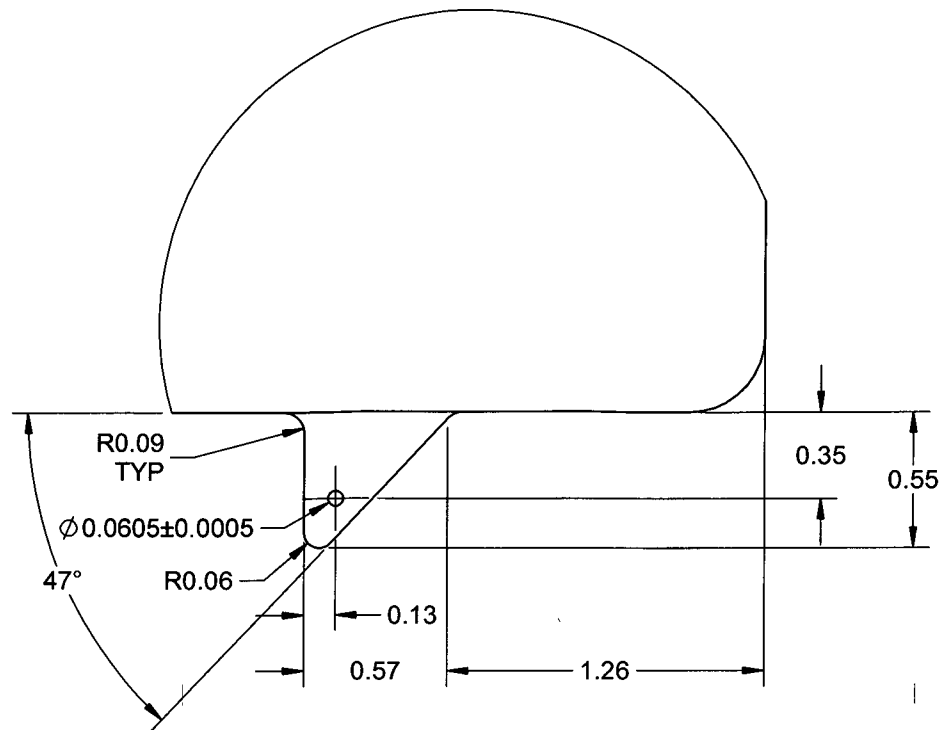
D5046-1 CO-PILOT COLLECTIVE HEAD (205)

APPROVED

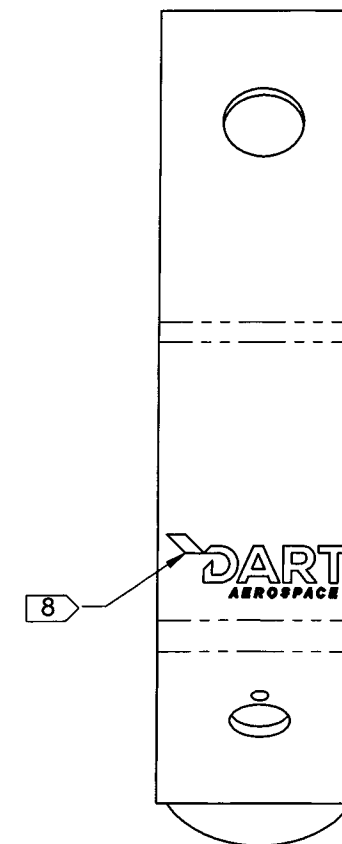
DESIGN	VS	DART AEROSPACE USA, INC.	
DRAWN	VS	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5046	SHEET 5 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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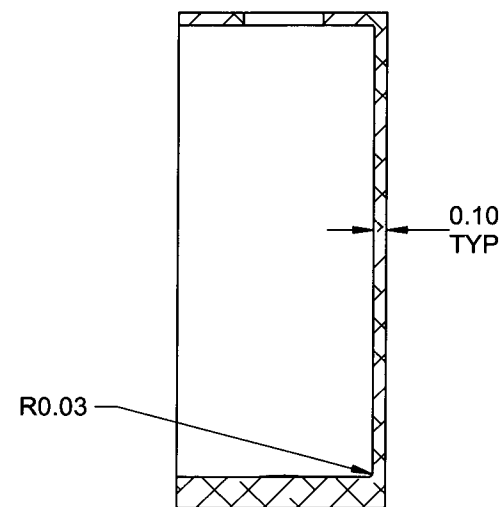
**VIEW A-A**  
B7-5



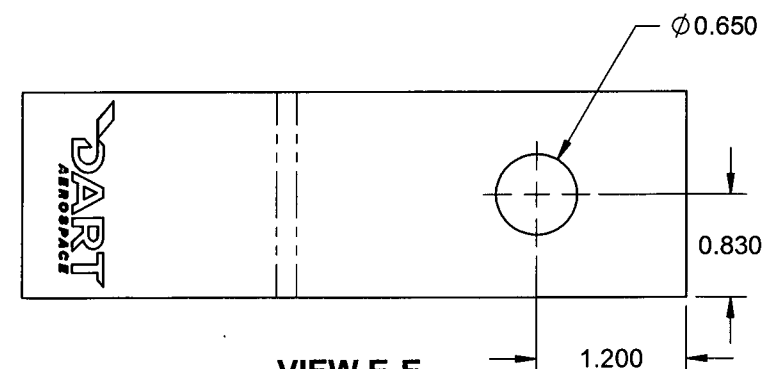
**DETAIL B**  
C2-5



**VIEW C-C**  
D6-5



**SECTION D-D**  
C2-5



**VIEW E-E**  
D3-5

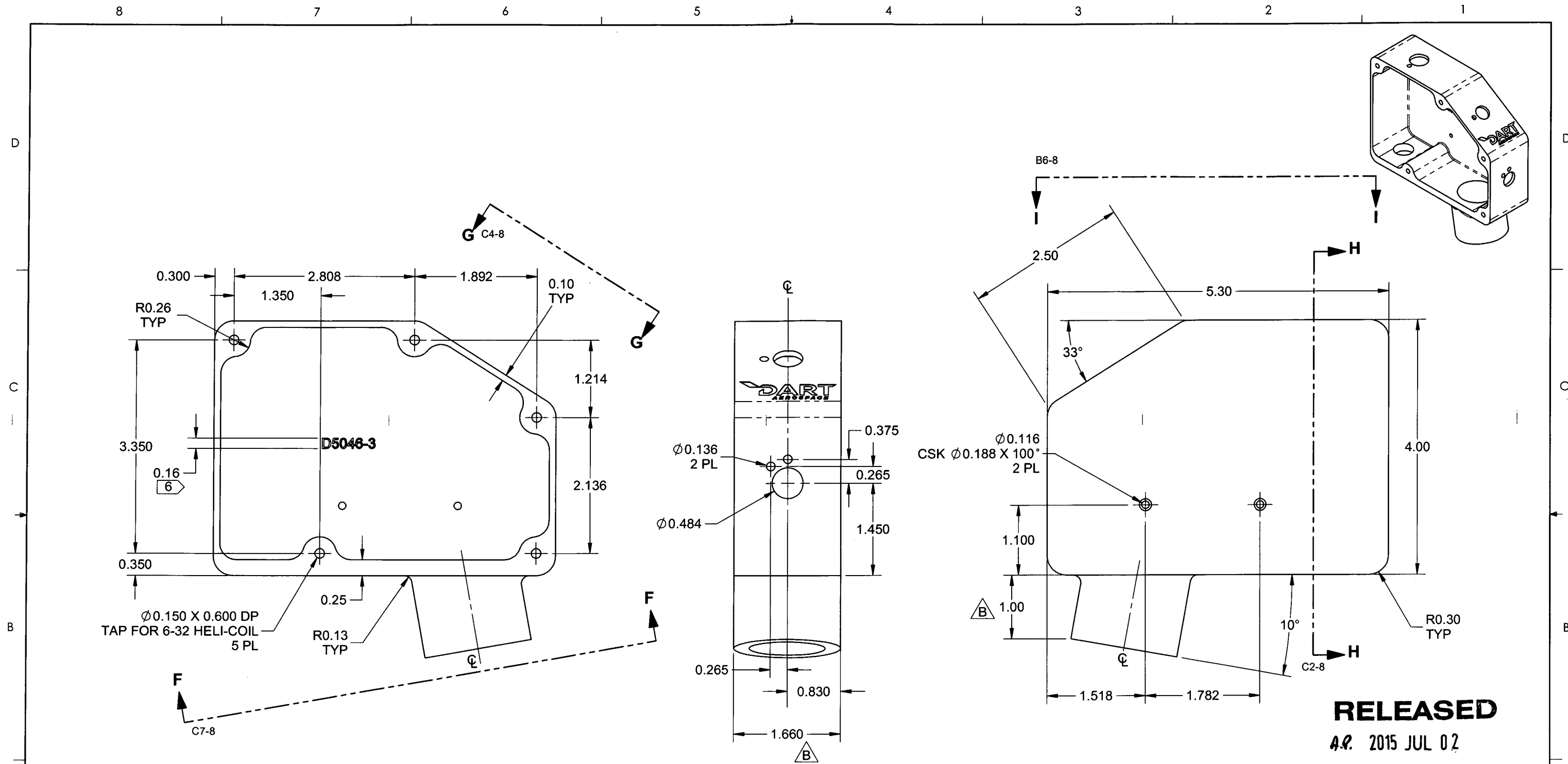
**RELEASED**  
A.P. 2015 JUL 02

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.80 lbs
  - 8) ENGRAVE "DART" LOGO AS SHOWN 0.003-0.005 DP

**D5046-1 CO-PILOT COLLECTIVE HEAD (205)**  
**DETAIL VIEWS**

APPROVED

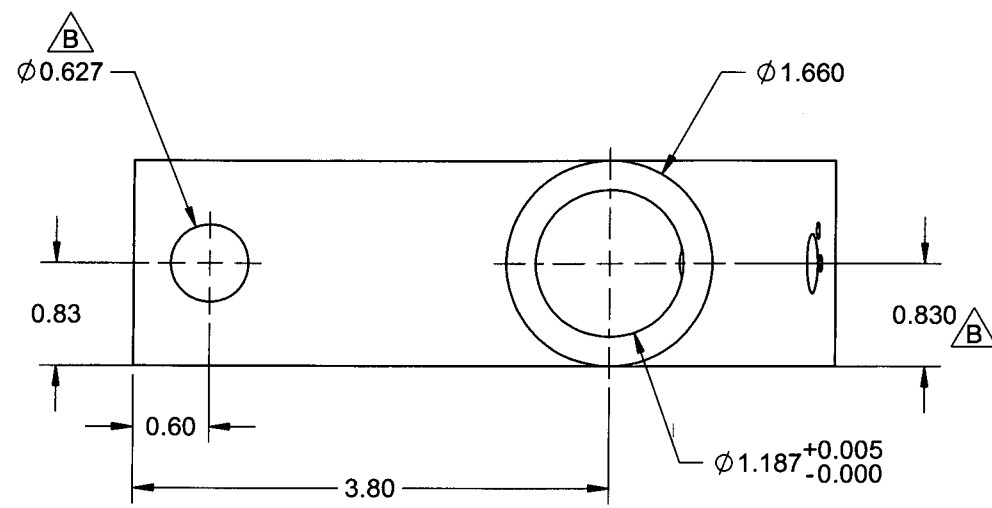
DESIGN	VS	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	VS	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	<b>D5046</b>	SHEET 6 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>CO-PILOT COLLECTIVE HEAD</b>	NTS
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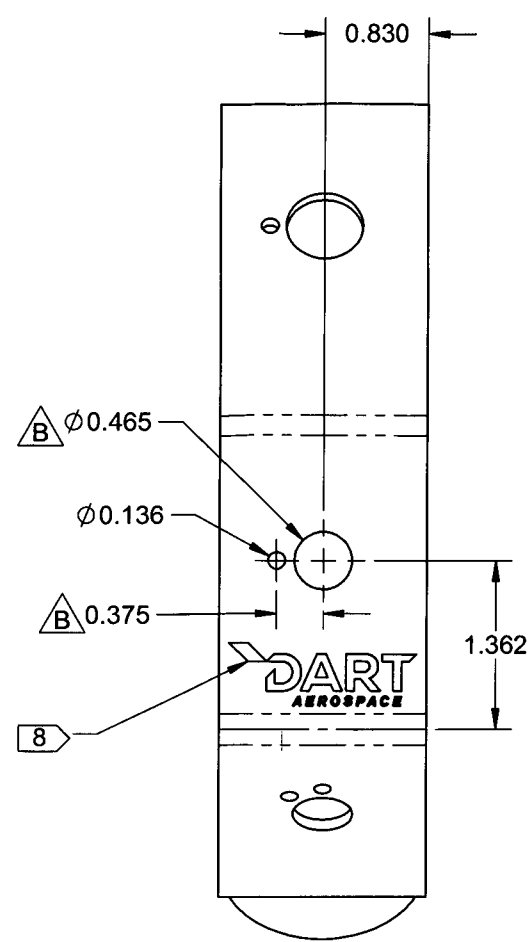
D5046-3 CO-PILOT COLLECTIVE HEAD (212)

- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH  
OF 0.010 WITH A MIN. TOOL RAD OF R0.010
  - 7) WEIGHT: 0.80 lbs

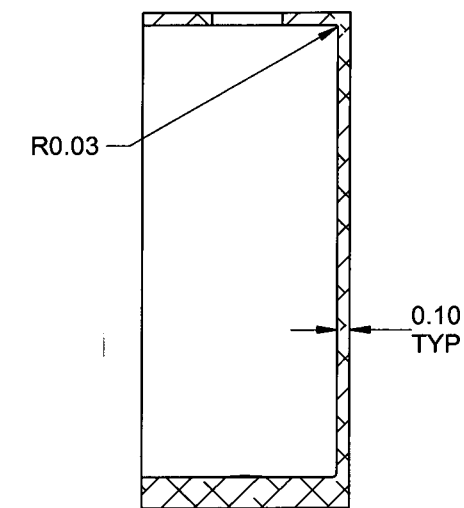
APPROVED	DESIGN	VS	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	VS		
	CHECKED	RF	DRAWING NO.	REV. B
	MFG. APPR.	JFS	D5046	SHEET 7 OF 12
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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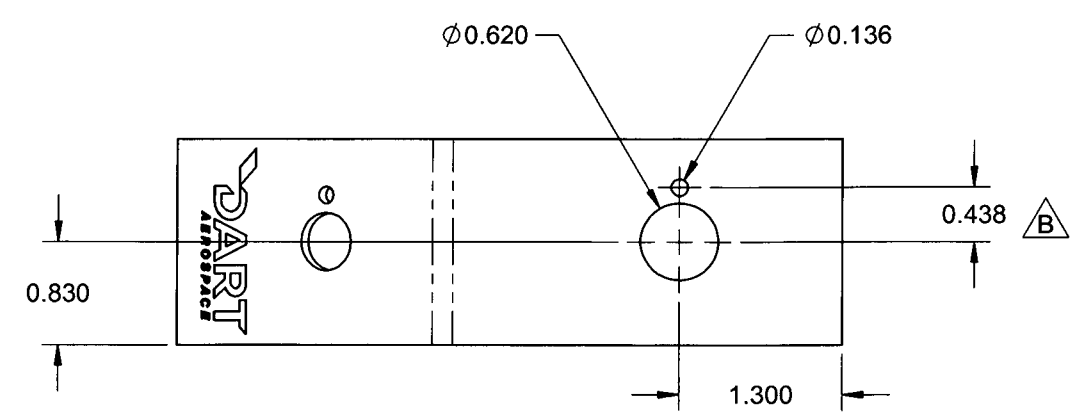
**VIEW F-F**  
B7-7



**VIEW G-G**  
D6-7



**SECTION H-H**  
C2-7



**VIEW I-I**  
D3-7

**RELEASED**  
A.P. 2015 JUL 02

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.80 lbs
  - 8) ENGRAVE "DART" LOGO AS SHOWN 0.003-0.005 DP

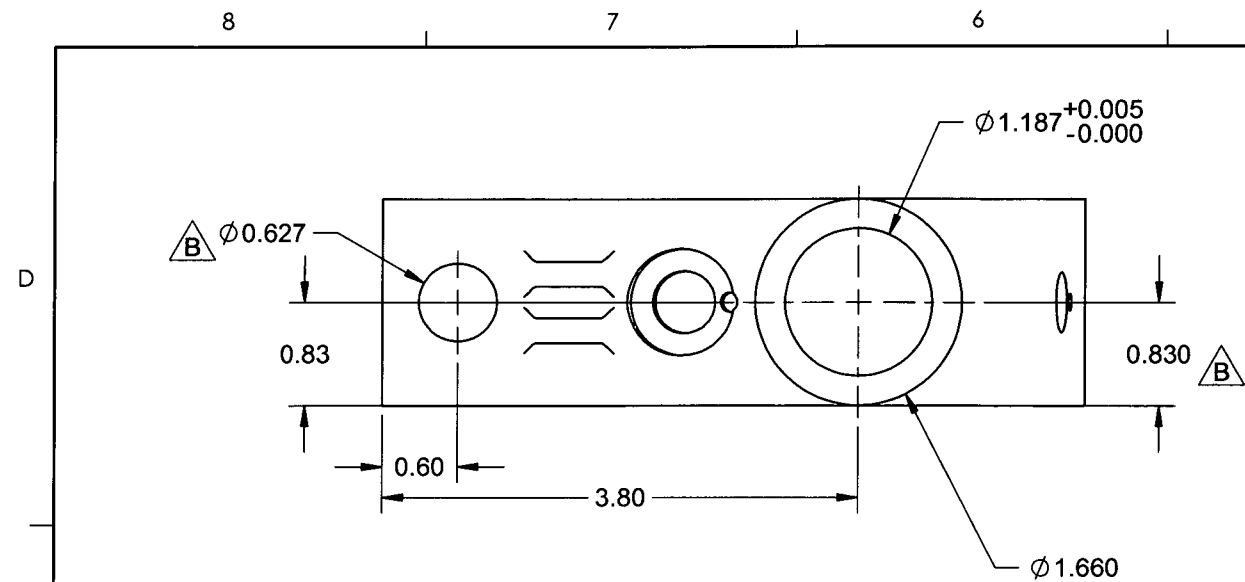
**D5046-3 CO-PILOT COLLECTIVE HEAD (212)**  
**DETAIL VIEWS**

APPROVED

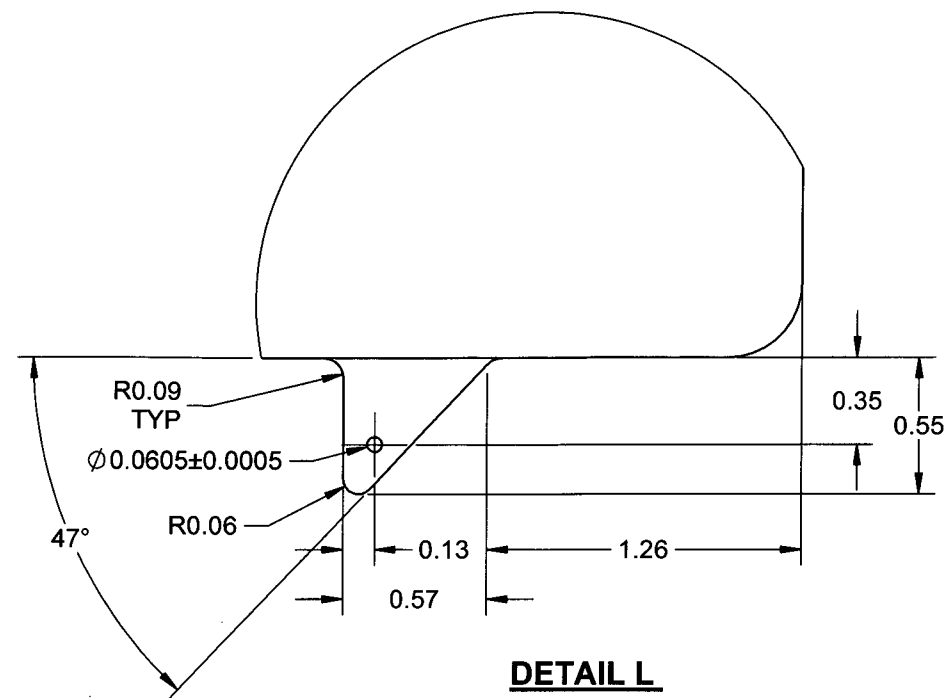
DESIGN	VS	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5046	SHEET 8 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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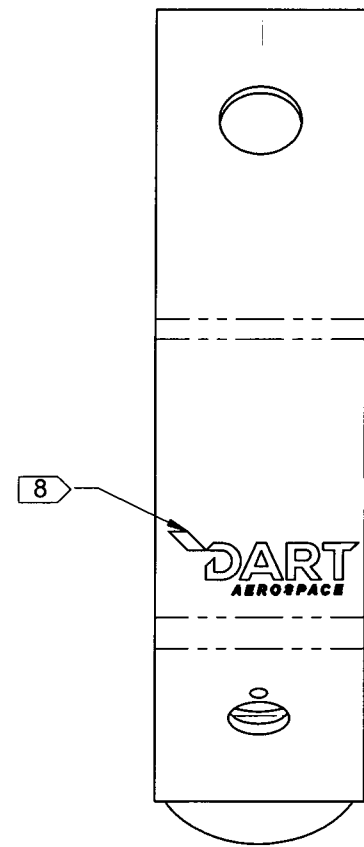




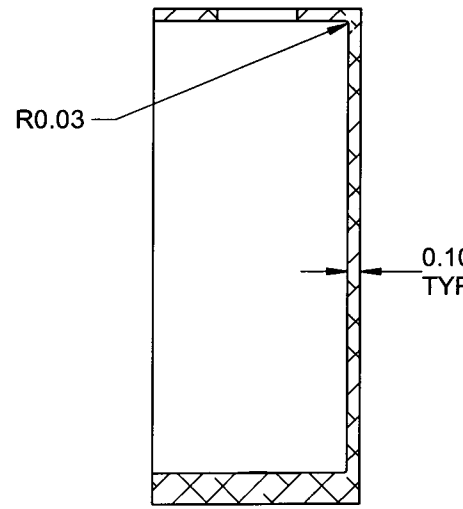
**VIEW K-K**  
B7-9



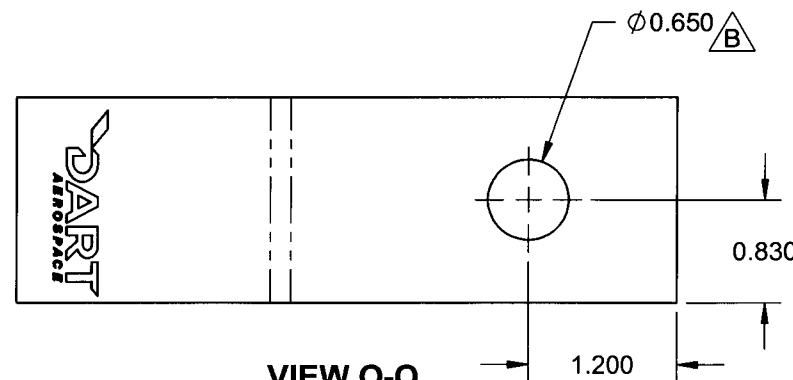
**DETAIL L**  
C2-9



**VIEW M-M**  
D6-9



**SECTION N-N**  
C2-9



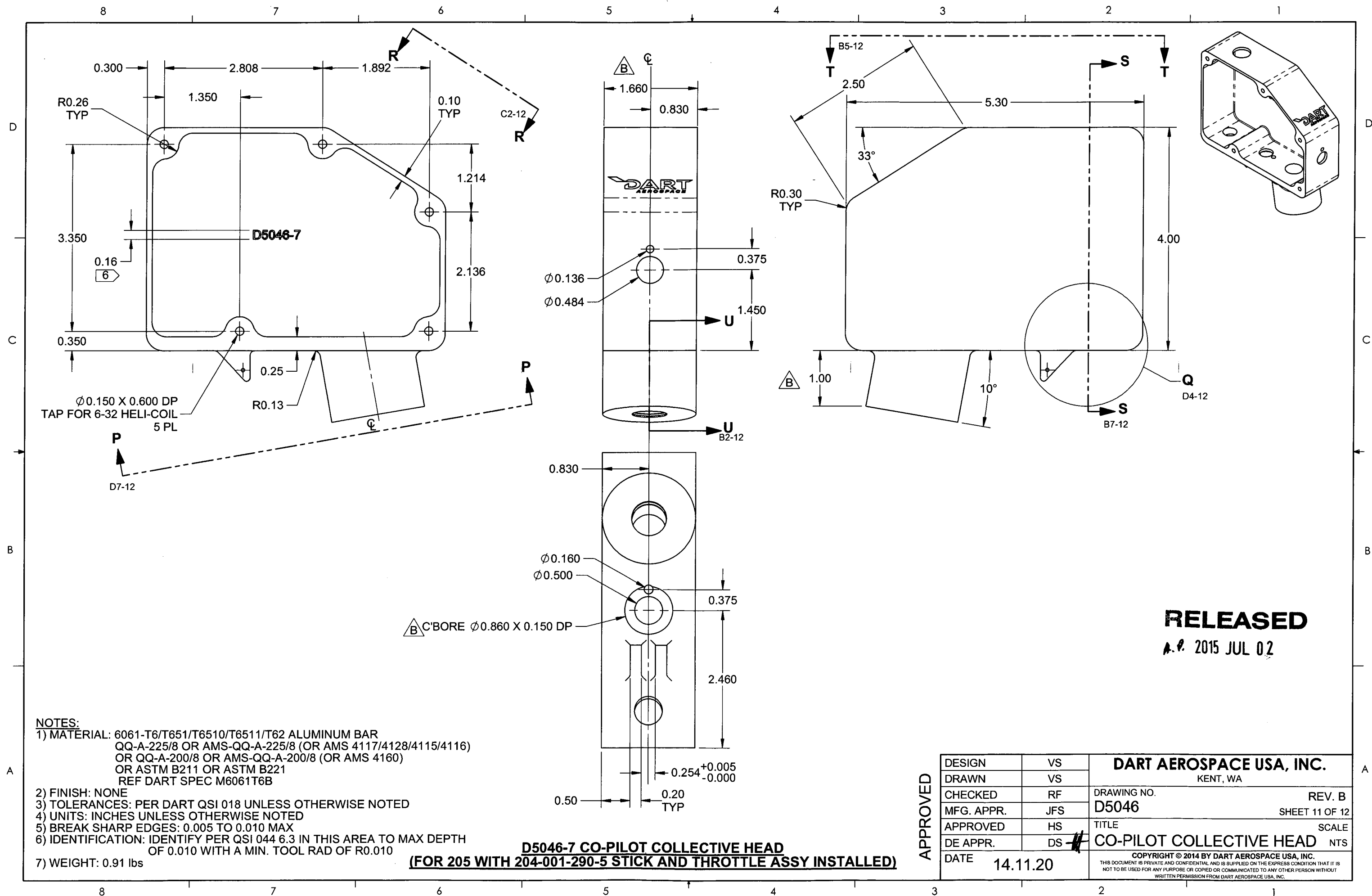
**VIEW O-O**  
D3-9

**RELEASED**  
D.P. 2015 JUL 02

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.80 lbs
  - 8) ENGRAVE "DART" LOGO AS SHOWN 0.003-0.005 DP

**D5046-5 CO-PILOT COLLECTIVE HEAD (EAGLE SINGLE)**  
**DETAIL VIEWS**

APPROVED	DESIGN	VS	<b>DART AEROSPACE USA, INC.</b>	
	DRAWN	VS	KENT, WA	
	CHECKED	RF	DRAWING NO.	REV. B
	MFG. APPR.	JFS	D5046	SHEET 10 OF 12
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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**NOTES:**  
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH  
OF 0.010 WITH A MIN. TOOL RAD OF R0.010  
7) WEIGHT: 0.91 lbs

**D5046-7 CO-PILOT COLLECTIVE HEAD**  
**(FOR 205 WITH 204-001-290-5 STICK AND THROTTLE ASSY INSTALLED)**

APPROVED

DESIGN	VS	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	<b>D5046</b>	SHEET 11 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>CO-PILOT COLLECTIVE HEAD</b>	NTS
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